

# Work Order ID 66394

Friday, June 17, 2011 8:42:07 AM



Page 1

Item ID: D3407-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stem

Start Date: 2/14/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 2/21/2011 Req'd Qty: 12.00

Customer:

Reference:

*Handwritten:* 16.07.11  
11.06.17

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100	DOOSAN LATHE	0.00							
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA597 Rev: <u>AA</u> & Dwg D3407 Rev: <u>E</u> □2-Deburr								

*Handwritten:* 20 11.6.22 16

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

*Handwritten:* 20 11.6.22 16

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

*Handwritten:* 20 11/6/22 16

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

T60 11/6/23 df

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/23 df  
mf  
11-06-23

# Picklist Print

Friday, June 17, 2011 8:42:03 AM

Page 1

Work Order ID: 66394

Parent Item: D3407-3

Parent Item Name: Stem





Start Date: 2/14/2011

Required Date: 2/21/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC  
IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD  
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased	No			100	f	17.9750	0.366	4.623158			
										Req 11.6.22			
17-4 round bar .750													
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					MAT030		17.975						
					117683		17.975			6.04			

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Stem</b>		<b>Part Number:</b>	<b>D3407-3</b>
<b>Inspection Dwg: D3407 Rev: E</b>		<b>Page 1 of 1</b>	

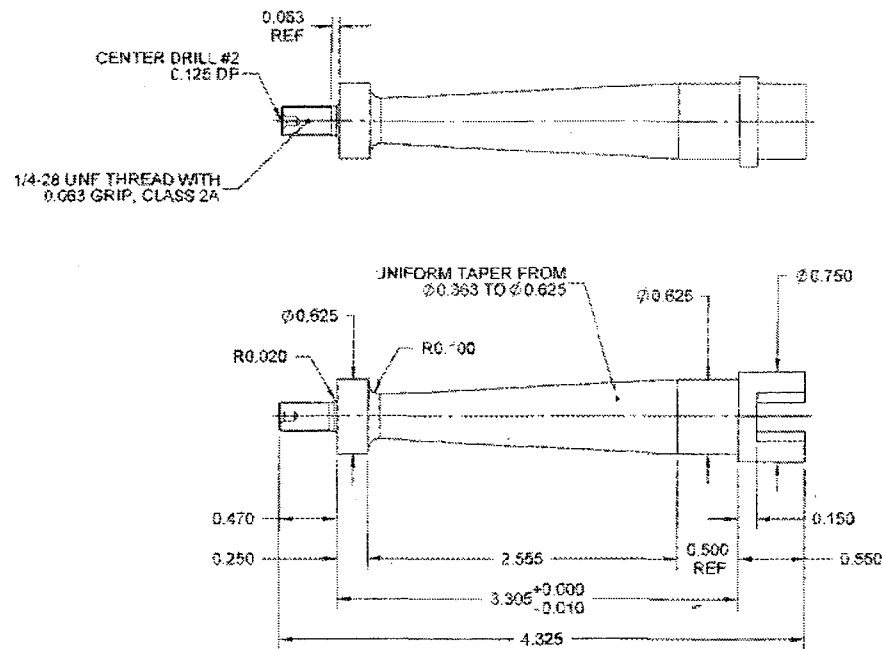
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/		RQ.02	
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.2655	/		RQ.06	
Major Ø	Max: 0.249 Min: 0.2425	.246	/		RQ.06	
Ø0.625	+/-0.010	.626	/		RQ.02	
Ø0.363	+/-0.010	.366	/			
Ø0.750	+/-0.010	.749	/			
R0.100	+/-0.010	2.100	/			
0.470	+/-0.010	.470	/			
0.250	+/-0.010	.253	/			
2.555	+/-0.010	2.550	/			
3.305	+0.000/-0.010	3.300	/			
4.325	+/-0.010	4.321	/			
0.150	+/-0.010	.154	/			
0.550	+/-0.010	.552	/			
0.625	+/-0.010	.622	/			
0.250	+0.010/-0.000	.251	/			

<b>Measured by:</b> <i>RQ</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11. C. 22	<b>Date:</b> 11/6/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	<i>[Signature]</i>



**D3407-3 STEM**

**NOTES:**

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

**RELEASED**

DESIGN	17-4	DART AEROSPACE USA, INC.	
DRAWN	17-4	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	03 07 23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	